W	ork	<b>Order</b>	ID	121	670
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## \*121670\*

Page 1

Thursday, June 26, 2014 3:06:25 PM Accept \*N900040100\* Setup Start Item ID: D3458-3 **Revision ID:** Stop **Item Name:** Step Mounting Plate \*4\* **Start Date:** 6/26/14 **Start Oty:** 4.00 **Cust Item ID:** Required Date: 6/26/14 Req'd Qty: 4.00 \*4\* **Customer:** Reference: Run Start Date: 14-06-30 Tooling: Process Plan: Mi 5 Date: **Approvals:** Stop Date: SPC (Y/N): QC: Date: Tool ID Tool # Plan Accept Reject Reject Insp. Sequence ID/ Operation Set Up/ Qty Qty Number Stamp Code Description **Work Center ID Run Hours Revision Nbr Draw Nbr** D3458 Rev A 100 0.00 FLOW WATER JET \*100\* 0.00 Waterjet Memo 1-Cut as per Dwg D3458 FLOW CNC Waterjet Dwg Rev: A Prog Rev: 2-Deburr if necessary DAS QC2- Inspect parts off machine FAI/FAIB 0.00 110 14-10-2 10 \*110\* δ 0.00 QC Memo Quality Control 0.00 QC8- Inspect parts - second check 120 \*120\* OC 0.00 Memo Quality Control

DQA:		- Date:		<del></del>	WORK ORDER NON-	.cc	אובטו	DMANCE / III	DUVIE				"DART
QA Closed:		Date:						WAITEL / O	IDAIL	W	ork Order up	date only	AEROSPACE
Work Orde	r·				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
Part N					Rework Scrap			Skid-tube Machining	Crosstube Small Fab			Water Jet	Engineering Quality
NCR N	o				Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	-	Rec/Stor	re/Packaging Supplier	Other
Root				Desci	ription of work order update		nitial	Act	tion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspector
Design		ļ											
Doc/Data		}											
Equip/Tooling								-					
Handling/Pre												·	
Material								:					
Operator			,										
Offset/Setup		1											
Process						ŀ							
Supplier		1											
Training													
Transport		İ		:									
Unapproved											·		
•		•				FA	ULT CA	EGORY					
Landin	g Gear	,			General							_	
	Bending				Bend		Folio/F	rogram			Outside Dim	ensions	Pressure/Forced
	Centre N	ot Conce	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	εί	Temperature/Cure
Ī	Crimp/Ki	nk/Ripple	e/Wave		Burrs	Г	Inspect	ion Incomplete/Ur	nqualified		Part Lost/Mi	ssing	Weld
ľ	Cuffs				Contamination		Instruct	ions Incomplete/l	Unclear		Part Moved		Wrong Stock Pulled
ľ	Crushing				Countersink		-	ned/off center			Positioned V	ے Vrong	_
ľ	Heat Tre				Cut Too Short		Mislabe			Γ	Power Loss/		Other
	Inspection		Tube		Drawing	Г	Misrea			_	•		······································
ŀ	Marks/C	-			Drill Holes	$\vdash$	Off-set						
ŀ	Turning		!		Finish	Г	4	Calibration					
ŀ	Wave/Tv	•			Fit/Function		4	Sequence					

Work Orde Thursday, June				*121	670*						Page 2	2
Item ID: Revision ID: Item Name:	D3458-3 Step Mou	nting Plate		Accept	*N900	<b>040</b>	100	)* s	Setup Star Stop	IV	S1* S2*	
Start Date: Required Date: Reference:	6/26/14	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:	_		Stan	4		
Approvals:	Process QC:		Date:	Tooling: SPC (Y/N):		ate: ate:		К	Run Star Stoj	^IV	R1* R2*	
Sequence ID/ Work Center I 130 *120* Small Fab Small Fab	D	Operation Description  Small Nab  Memo Deburr pare	DAS 38 9-89 per dwg D3458	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	

140

\*140\*

Quality Control

Inspect part completeness to step on W/O

DAS **38** 9-89

0.00

14/10/02.

150

\*150\* Packaging

Packaging

Identify as per dwg & Stock Location: WADOS

0.00

Memo

0.00

\*\*\* STOCK IN STEP CELL\*\*\*

14-10-2 DMC

DQA:			Date:			MODE ORDER MON	~	אורטו					`DART
QA Closed:			Date:			WORK ORDER NON-	٠رر	NFOI	RIVIAINCE / UF		ork Order up	odate only	AEROSPACE
Marili Orda						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde	er: –	<del></del>				Downsk	Ì		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	اما					Rework Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
Faitiv	<b>'</b> '					Use-as-is	١		noforming	Finishing	1	re/Packaging	Other
NCR N	lo.					Suspected Unapproved		1110111	Large Fab	Composite	1100,000	Supplier	1 341161
	_									,			
Root					Desci	ription of work order update	١	nitial	Acti	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Design													
Doc/Data	$\Box$	1											
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Handling/Pre	Ш		1										
Material	$\Box$												
Operator													
Offset/Setup					İ								
Process													
Supplier		:											
Training													
Transport													
Unapproved			L										
		· <u>.</u>					FAI	ULT CA	FEGORY				
Landi	ng G	ear			_	General		1		<b></b>	7	_	<b>¬</b>
	$\vdash$	Bending				Bend			rogram	_	Outside Dim	<u> </u>	Pressure/Forced
	Щ	Centre No	ot Concer	ntric	$\perp$	BOM/Route		Grain			Over/Under	tolerance	Set-up
	$\vdash$	Cracks			_	Broken/Damage/Defect		Hardwa		·	Part Incorred	<del></del>	Temperature/Cure .
	Ш	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing	Weld
	Ш	Cuffs				Contamination		4	tions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled
	Ш	Crushing				Countersink		1	ned/off center		Positioned V		<b>¬</b>
	Ш	Heat Trea	at		<u> </u>	Cut Too Short	$\vdash$	Mislabe			Power Loss/	Surge	Other
	Ш	Inspection	n Strip in	Tube		Drawing	L	Misrea					
	Ш	Marks/Ch	natter		L	Drill Holes		Off-set					
		Turning S	equence			Finish	L	Out of	Calibration				
		Wave/Tw	ist in Tul	эе		Fit/Function		Out of	Sequence				

Work Order ID 121670 Thursday, June 26, 2014 3:06:25 PM

\*121670\*

Page 3

Item ID:

D3458-3

Accept

\*N900040100\*

Setup Start

**Revision ID:** 

Item Name:

Required Date: 6/26/14

Step Mounting Plate

Start Oty: 4.00 6/26/14

Req'd Qty: 4.00

\*4\* \*4\*

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

**Start Date:** 

**Approvals:** 

Process Plan:

QC:

Date: Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Start

Stop

Stop

Sequence ID/ **Work Center ID**  Operation **Description**  Set Up/ **Run Hours** 

Tool # Plan

Accept Qty Code

Reject Qty

Run

Reject Number Stamp

Insp.

160

QC21- Final Inspection - Work Order Release

0.00

\*160\*

Memo

0.00

Quality Control

DQA:			Date:											DART
QA Closed:			Date:		•	WORK ORDER NON-	-CC	ONFOI	RMANCE / UI		ork Order up	odate only		AEROSPACE
147 - ul. Oud.						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Work Orde	er: -					D [	ıl		C1124 A. J. L.	C	7	Water Jet	_	Casinossino
Part N	10				<del></del>	Rework Scrap Use-as-is			Skid-tube  Machining  noforming	Crosstube Small Fab Finishing	-1	d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR N	۱٥					Suspected Unapproved		mem	Large Fab	Composite		Supplier		Other
Root					Desc	ription of work order update		nitial	Act	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	۱	QC Inspector
Design				•				<u>-</u>						
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator				<u> </u>			Ì							
Offset/Setup							ļ						İ	
Process														
Supplier														
Training					:									
Transport														
Unapproved		,												
							FAI	ULT CA	regory					
Landi	ng G	ear	·	-		General					_			
W	П	Bending				Bend		Folio/F	rogram		Outside Dim	ensions		Pressure/Forced
Ÿ		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ci [		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	issing		Weld
		Cuffs				Contamination		Instruct	ions Incomplete/U	Jnclear	Part Moved	ſ		Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong		
		Heat Trea				Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
	Г			Tube		Drawing		Misrea	d		·	_		
						Drill Holes		Off-set						
						Finish		-	Calibration		•			
						Fit/Function	Г	Out of	Sequence					
	Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube													

## **Picklist Print**

1 , ,

Thursday, June 26, 2014 3:06:25 PM

Work Order ID: 121670

\*121670\*

Parent Item:

D3458-3

\*D3458-3\*

Parent Item Name: Step Mounting Plate

**Start Date:** 6/26/14

Required Date: 6/26/14

Start Qty: 4.00

Required Qty: 4.00

**Comments:** 

IPP REV. A 05.12.13 NEW ISSUE

Item Name Item ID Purch Item Location Location	Seq ID	Measure	Hand		Qty	Issued	Issued	
--	--------	---------	------	--	-----	--------	--------	--

M6061T6B0.187X04.00

Purchased

No

100

66.1168

\*\*

0.0427

0.17979

0.5

DAS

Page 1

\*M6061T6B0 187X04 000\*

6061-T6 Bar .187 x 4.00

Location	Loc Oty	Loc Code
MAT051	66.116842	
m128265	16.116842	
m129411	50	

12559 50

125590

DQA:		. Date:			MODIC ORDER MON	~		DAAANCE / LIDDATE				`DART
QA Closed:		Date:			WORK ORDER NON-	-((	JNFOR	RIVIANCE / UPDATE	W	ork Order up	date only	AEROSPACE
					DISPOSITION			AGAINS'	T DE	PARTMENT	/PROCESS	
Work Orde	r:				, ,	.		Children Comments	_	1	Water Jet	
Part N	0.	<del></del>		_	Rework Scrap Use-as-is		1	Skid-tube Crosstube  Machining Small Fal  noforming Finishing		4	d. Eng. Coor.	Engineering Quality Other
NCR N	0		··••		Suspected Unapproved			Large Fab Composite	- ⊢	nec/stol	Supplier	
Root				Desc	ription of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Design								·				
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material		<u>.</u>										
Operator		1										
Offset/Setup							•					
Process												
Supplier												
Training			ļ									
Transport					•							
Unapproved												
						FΑ	ULT CAT	regory				
Landir	ng Gear				General		_			-	_	_
	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Centre N	ot Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re	L	Part Incorre	cí _	Temperature/Cure
	Crimp/Ki	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	issing	Weld
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong	_
	Heat Tre	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	Inspection	n Strip ir	Tube		Drawing		Misrea	d	_		<u> </u>	
	Marks/C	hatter			Drill Holes		Off-set			-		
	Turning 9	Sequence	<u>:</u>		Finish		Out of	Calibration				
	Turning Sequence Wave/Twist in Tube				Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order:	161070
Description: Step Mounting Plate	Part Number:	D3458-3
Inspection Dwg: D3458 Rev: A		Page 1 of 1

	X	First Artic	le	Proto	type	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.041	+/-0.010	2041			v	Jbmo 7
Ø0.257	+0.006/-0.001	0 357°			J	
0.703	+/-0.010	6.703	_		<b>V</b>	
R0.125	+/-0.010	0.125	_		RG	
1.037	+/-0.010	1.037			ν	
R0.386	+/-0.010	0.386			RG-	
3.080	+/-0.010	3000			V -	
			200			
	DAS		1 - 84 - 36			
leasured by:	23 9-89	Audited by:	9-89		Prototype A	pproval: N/A  Date: N/A

Rev	Date	Change	Revised by	Approved
Α	06.04.28	New Issue	KJ/JLM O	1— <i>7811</i>

SHI R0.437 DOCUMENT IS 2.041 -SHOP COLY R0.386 RETURN 70 Ø0.257 Copyright © 2005 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. **ENGINEERING** (TYP) **UNCONTROLLED** COLY SUBJECT TO AMENDMENT WITHOUT NOTICE 0.703 WORK ORDER 3.080 D2622 14-06-30 **EXTRUSION** 0.703 PROFILE D2622 R<sub>0.125</sub> **EXTRUSION** DATE PROFILE 05.09.23 3.080 1.037 0.863 R<sub>0.125</sub> 05.09 Ø0.257 (TYP) .23 R0.386 R0.500 2.041 DRAWING NO. STEP MEM MOUNTING **JUSSI** D3458-3 STEP MOUNTING PLATE D3458-1 STEP MOUNTING PLATE PLATE \$1.11.50 D3458-1/-3 STEP MOUNTING PLATE MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK (REF DART SPEC. M6061T6S.188) PURPOSE NONE 2) FINISH: ALL DIMENSIONS ARE IN INCHES 3) SHEET 1 OF 1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 0 COPIED

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AEROSPACE PORT HADLOCK.

<sup>™</sup>USA,

NC.

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